

JUN 21 2018

Plw



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-559-013
Job Sheet 178924



Part No: D206-559-013

Job Qty: 2 ea

Part Name: 206L Series / 407 Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV L SHEET 7 IPP Rev:J 04.02.17 Blank size changed KJ/JLM IPP Rev:K 07-01-02 Was K10008 JLM
IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified
by:EC IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified By:EC IPP Rev G 10.10.04 per DSI9527
EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Stores/Pkg-2		
160	Packaging	2 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-2		
170	QC	2 pcs	7/6/18	7/6/18	0.00	0.00	QC4		
180	Packaging	2 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		
185	DC	2 pcs	7/6/18	7/6/18	0.00	0.00	DC		
190	QC21-FG	2 Ea	7/6/18	7/6/18	0.00	0.00	QC21		

Part Op 180 - Identify and pack for shipping as per PPPD206-559-013 LOCATION: FG013
Descriptions: 185 - Photocopy bluefile and create labels per PPP D206-559-013 CHG006

DAS
21
9-89

JUL 04 2018

Fg013

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-17A	Bolt	24 Ea (12 ea)	90-Start up Operation	
AN4-20A	Bolt	24 Ea (12 ea)	90-Start up Operation	
D2182B050	Clamp Cushion Black 5.0 " Long	12 Ea (6 ea)	90-Start up Operation	
D2274	Radius Block	24 Ea (12 ea)	90-Start up Operation	
D2432	Bearpaw 19" X 24"	4 Ea (2 ea)	90-Start up Operation	
D2438	Clamp	12 Ea (6 ea)	90-Start up Operation	
D2529	Washer	24 Ea (12 ea)	90-Start up Operation	
D2732-050	Rubber Cushion - 5"	12 Ea (6 ea)	90-Start up Operation	
MS21042L4	Nut	24 Ea (12 ea)	90-Start up Operation	
NAS1149D0463J	Washer	48 Ea (24 ea)	90-Start up Operation	

S080941 ~~5064~~ 8710

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-17A	24	344	0
	AN4-20A	24	94	0
	D2182B050	12	120	0
	D2274	24	251	0
	D2432	4	14	0
	D2438	12	64	0
	D2529	24	1,837	0
	D2732-050	12	145	0

MS21042L4
NAS1149D0463J

24
48

2,959
5,122

0
0

Part Specifications

Specifications could not be found.

Plex 6/11/18 10:26 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003998	S083084	AN4-17A	Bolt	S056003	ST343	24
003998	S083083	AN4-20A	Bolt	S054106	ST343	24
003998	S048299	D2182B050	Clamp Cushion Black 5.0 " Long	S048299	ST639	12
003998	S083060	D2274	Radius Block	s067935	ST006	24
003998	S083076	D2438	Clamp	S057738	ST542	12
003998	S083061	D2529	Washer	s035698	ST008	24
003998	S083041	D2732-050	Rubber Cushion - 5"	S038903	ST010	12
003998	S083038	MS21042L4	Nut	S067898	ST303	24
003998	S083034	NAS1149D0463J	Washer	S067900	ST263	48

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D2432

Plex 6/21/18 3:26 PM dart.quirion.sonia

Change Record

PAGE 1 OF 1

Part Number: D206-559-013

Description: BEARPAW INSTALLATION (206/407)[illegible]

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP